

Work Order ID 154388

Monday, December 12, 2016 2:25:38 PM

154388

Page 1

Item ID: 647.7328 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: EC135 T3/P3 Upper Cutter Removable Provisions
Start Date: 12/12/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 12/16/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan:  Date: DEC 15 2016 Poling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
MPP-195	11/C								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP 647.7328								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

DEC 19 2016

DEC 19 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		FAULT CATEGORY		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : ☐							

154388

Monday, December 12, 2016 2:25:38 PM

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: EC135 T3/P3 Upper Cutter Removable Provisions

Start Date: 12/12/2016 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 12/16/2016 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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0.00

130

Packaging

0.00

Packaging

Memo

Packaging

Identify and pack for shipping as per PPP 647.7328
Location : FG109

DAS 28 9-89

DEC 19 2016

0.00

140

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

Quality Control

DAS
21
9-89

DEC 20 2016

DAS
21
9-89

DEC 20 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐			FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		
OTHER : ☐					

Monday, December 12, 2016 2:25:43 PM

154388

647 7328

Required Date: 12/16/2016

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

647 7701

647.0112	Manufactured	No
----------	--------------	----

647 0112

Strut Bracket

Location**Loc Qty****Loc Code**

CCK107

41

150114

16

150895

15

151894

10

AN44-12A	Purchased	No
----------	-----------	----

AN44-12A

Eyebolt

Location

Loc Qty

Loc Code

ST339

12

124263

12

AN665-34R	Purchased	No
-----------	-----------	----

AN665-34R

Cleviss

Location

Loc Qty**Loc Code**

over008

47

153852

47

ST330

37

M135948

11

M136182

26

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:12.5%;">Skid-tube ☐</td> <td style="width:12.5%;">Cross tube ☐</td> <td style="width:12.5%;">Water Jet ☐</td> <td style="width:12.5%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																							
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																								OTHER :																																							

Picklist Print

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Page 2

Work Order ID: 154388

154388

Parent Item: 647.7328

647 7328

Parent Item Name: EC135 T3/P3 Upper Cutter Removable Provisions

Start Date: 12/12/2016

Required Date: 12/16/2016

Start Qty: 1.00

Required Qty: 1.00

AN3-11A Purchased No

Each 686.0000 2

AN3-11A

Bolt

DAS
6
9-89

DEC 15 2016

DAS
28
9-89

Location

Loc Qty

Loc Code

over003

664

153855

564

m136192

100

ST349

22

m135767

22

AN4C7A Purchased No

Each 136.0000 2

AN4C7A

BOLT

DAS
6
9-89

DEC 15 2016

DAS
28
9-89

Location

Loc Qty

Loc Code

OVER002

124

m135864

70

m136295

54

ST345

12

m135470

12

MS21042-08 MS21042L08 Purchased No

Each 0.0000 2

MS21042-08

USE MS21042L08

136/99

DAS
6
9-89

DEC 15 2016

DAS
28
9-89

DAS
27
9-89

Monday, December 12, 2016 2:25:43 PM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step # : _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

Picklist Print

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Work Order ID: 154388

154388

Parent Item: 647.7328

647 7328

Parent Item Name: EC135 T3/P3 Upper Cutter Removable Provisions

Start Date: 12/12/2016

Required Date: 12/16/2016

Start Qty: 1.00

Required Qty: 1.00

MS21042L4

Purchased

No

Each

2,602.000

2

MS21042L4

Nut

Location

Loc Qty

Loc Code

FP001

18

m133363

18

GA

196

m135058

196

OVER007

1500

m136182

500

m136295

1000

ST303

888

153851

3

m135864

385

m135979

500

DAS
6
9-89

DEC 15 2016

DAS
28
9-89

DAS
27
9-89

AN316C4R

Purchased

No

Each

89.0000

2

AN316C4R

Nut, Jam

Location

Loc Qty

Loc Code

ST331

89

153850

50

m135840

4

m136192

35

DAS
6
9-89

DEC 15 2016

DAS
28
9-89

DAS
27
9-89

MS27039-08-13

Purchased

No

Each

471.0000

2

MS27039-08-13

Screw

Location

Loc Qty

Loc Code

over006

325

153849

325

ST278

146

124326

46

m136199

100

DAS
6
9-89

DEC 15 2016

DAS
28
9-89

DAS
27
9-89

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Page 3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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OTHER : _____																																																															

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Work Order ID: 154388

154388

Parent Item: 647.7328

647 7328

Parent Item Name: EC135 T3/P3 Upper Cutter Removable Provisions

Start Date: 12/12/2016

Required Date: 12/16/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149FN832P

Purchased

No

Each

2,081.000

19

NAS1149FN832P

Washer

DAS
6
9-89

DEC 15 2016
DAS
28
9-89

Location

Loc Qty

Loc Code

GA

449

M135058

449

ST260a

1500

M136182

1500

ST263

132

M135058

132

19

NAS1149C0432R

Purchased

No

Each

1,775.000

4

NAS1149C0432R

WASHER

DAS
6
9-89

DEC 15 2016
DAS
28
9-89

Location

Loc Qty

Loc Code

GA

373

m134676

373

ST260a

1000

m136182

1000

ST266

402

m135979

402

4

NAS1149F0532P

Purchased

No

Each

1,629.000

2

NAS1149F0532P

Washer

DAS
6
9-89

DEC 15 2016
DAS
28
9-89

Location

Loc Qty

Loc Code

ST260a

600

m133725

600

ST262

1029

18057

1029

2

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Page 4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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Work Order ID: 154388

154388

Parent Item: 647.7328

647 7328

Parent Item Name: EC135 T3/P3 Upper Cutter Removable Provisions

Start Date: 12/12/2016

Required Date: 12/16/2016

Start Qty: 1.00

Required Qty: 1.00

601.2045 Purchased No

Each 15.0000 1

601 2045 ✓

RTV (LOCTITE 598)

**

DAS
6
9-89

DAS
28
9-89

DEC 15 2016

Location	Loc Qty	Loc Code
CCK096	7	
m136171	7	
GA	8	
m134260	8	

MS27039-08-19 Purchased No

Each 267.0000 5

MS27039-08-19

Screw

**

134502

DAS
6
9-89

DEC 15 2016

DAS
28
9-89

Location	Loc Qty	Loc Code
GA	164	
m135948	164	
ST277	103	
m136042	1	
m136199	52	
m136301	50	

MS21042L08 Purchased No

Each 929.0000 5

MS21042L08

Nut

**

DAS
6
9-89

DAS
28
9-89

DEC 15 2016

Location	Loc Qty	Loc Code
GA	528	
m135274	28	
m135978	500	
ST303	401	
m135948	1	
m136199	200	
m136301	200	

Monday, December 12, 2016 2:25:43 PM

Shop Packet Print

Page 5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐				
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval		
Description Work Order Deviation			Disposition			
						Completed By
						Lead hand / Supervisor Approval Verification
						QC / QA Coordinator Approval
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐			FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐						

Picklist Print

Page 6

Monday, December 12, 2016 2:25:43 PM

Work Order ID: 154388

154388

Parent Item: 647.7328

647 7328

Parent Item Name: EC135 T3/P3 Upper Cutter Removable Provisions

Start Date: 12/12/2016

Required Date: 12/16/2016

Start Qty: 1.00

Required Qty: 1.00

647.1405

Manufactured No

Each

0.0000

1

647 1405

Upper Cutter Assembly

153311

DAS
28
9-89

DEC 19 2016

DAS
6
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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SUBJECT:
Manufacturing Process Procedure
EC-135 CCK Configuration Management

DOCUMENT NO:
MPP-195
Rev. N/C
12/15/16

Table 9: T3/P3 UC Removable Provisions Kit, 647.7328

FIND #	PART #	DESCRIPTION	QTY
11	647.7701	STRUT ASSY	2
14	647.0112	STRUT BRACKET	2
39	601.3120	EYE BOLT	2
40	601.3119	CLEVIS	2
46	601.2826	BOLT	2
48	601.2669	BOLT	2
52	601.2973	LOCKNUT	2
54	601.3209	LOCKNUT	2
55	601.3128	NUT	2
61	601.2988	SCREW	2
85	601.2764	WASHER	19
87	601.3663	WASHER	4
88	601.3126	WASHER	2
91	601.2045	RTV	A/R
96	647.5701	GPS MOUNT KIT	1
100	601.2765	SCREW	5
101	601.1541	LOCKNUT	5
111	647.1405	CUTTER ASSY (UPPER)	1

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 154388
DEC 15 2016



REFERENCE ONLY

SUBJECT:
Manufacturing Process Procedure
EC-135 CCK Configuration Management

DOCUMENT NO:
MPP-195
Rev. N/C
12/15/16

Table 9: T3/P3 UC Removable Provisions Kit, 647.7328

FIND #	PART #	DESCRIPTION	QTY
11	647.7701	STRUT ASSY	2
14	647.0112	STRUT BRACKET	2
39	601.3120	EYE BOLT AN44-12A	2
40	601.3119	CLEVIS AN66S-34R	2
46	601.2826	BOLT AN3-11A	2
48	601.2669	BOLT AN4CTA	2
52	601.2973	LOCKNUT NAS1042-08	2
54	601.3209	LOCKNUT NAS1042L4	2
55	601.3128	NUT AN36C4R	2
61	601.2988	SCREW MS27039-08B	2
85	601.2764	WASHER NAS1149F0830P	19
87	601.3663	WASHER NAS1149C0430R	4
88	601.3126	WASHER NAS1149F0530R	2
91	601.2045	RTV	A/R
96	647.5701	GPS MOUNT KIT	1
100	601.2765	SCREW MS27039-0827	5
101	601.1541	LOCKNUT MS21042L08	5
111	647.1405	CUTTER ASSY (UPPER)	1

n/a

Work Order ID 154388

Friday, December 16, 2016 10:24:33 AM

154388

Page 1

Item ID: 647.7328

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: EC135 T3/P3 Upper Cutter Removable Provisions

Start Date: 12/12/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 12/16/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run Start *NR1*
	QC:	Date:	SPC (Y/N):	Date:	Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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MPP-195	N/C
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100	Document Control	0.00
100	DOCUMENT CONTROL	
DC	Memo	0.00
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP 647.7328	

DAS
21
9-88

DEC 16 2016

110	Pick Kit	0.00
-----	----------	------

110		
Packaging	Memo	0.00
Packaging		

120	QC4- 100% Inspect kits for completeness	0.00
-----	---	------

120		
QC	Memo	0.00
Quality Control		

Marie Lajeunesse

From: Kim Johnston
Sent: Friday, December 16, 2016 9:51 AM
To: Marie Lajeunesse
Subject: FW: EC135 CCK MPP & IIN corrections

Thanks,

Kim Johnston
*Engineering Clerk
Document Administrator*

DART AEROSPACE
T 1 613 632-5200 > ext. 226
F 1 613 632-9311



From: Sian Willems
Sent: Monday, December 12, 2016 9:21 AM
To: Lisa McMachen <lmcmachen@dartaero.com>; Kim Johnston <kjohnston@dartaero.com>
Subject: RE: EC135 CCK MPP & IIN corrections

Go ahead and load. A corrected version will follow once DaveM makes the updates.

SIAN WILLEMS
Customer Support Manager

DART AEROSPACE
T +1-613-632-3336 > 239
M +1-613-676-0577
F +1-613-632-5146
+1-800-556-4166
www.dartaerospace.com

From: Lisa McMachen
Sent: Monday, December 12, 2016 8:26 AM
To: Kim Johnston <kjohnston@dartaero.com>; Sian Willems <swillems@dartaero.com>
Subject: FW: EC135 CCK MPP & IIN corrections

Hi Sian,
Kim says that the paperwork is not jiving...can we load the attached documents to the website as discussed on Friday? Please see the attached email.

Thanks,
Lisa McMachen

From: Sian Willems
Sent: Monday, December 12, 2016 7:21 AM